



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2278
Job Sheet 179672



Part No: D2278

Job Qty: 12 ea

Part Name: Step Leg



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 7/11/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP Rev:A New Issue 05-11-07 JLM IPP Rev:B Now 6061-T6 06-06-23 JLM IPP Rev C New flat pattern 08.01.11 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		7/11/18	0.00	0.00	Start Up Waterjet		SL 7/10/18
100	Waterjet	12 pcs		7/11/18	0.01	1.35	Waterjet1		SL 7/10/18
110	QC	12 pcs		7/11/18	0.00	0.00	QC2		SL 7/10/18
120	QC	12 pcs		7/11/18	0.00	0.00	QC8		38
130	HandFinish	12 pcs		7/11/18	0.00	0.32	HandFinish1		SA 07-11
140	QC	12 pcs		7/11/18	0.00	0.00	QC7		38
150	Packaging	12 pcs		7/11/18	0.00	0.00	Packaging3		9-89
160	QC21-SA	12 Ea		7/11/18	0.00	0.00	QC21		JUL 13 2018

Part Op 100 - 1-Cut as per Dwg D2278
Descriptions: 150 - LOCATION : GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	11.7780 sf (.9815 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.080	12	78	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Leg	0.354Inches ± 0.010	0.364 0.344	0,357	
2	Leg	0.354Inches ± 0.010	0.364 0.344	0,356	
3	Leg	16.460Inches ± 0.030	16.490 16.430	16,468	
4	Leg	0.128Inches + 0.005 - 0.000	0.133 0.128	0,131	
5	Leg	0.354Inches ± 0.030	0.384 0.324	0,354	Radius
6	Leg	2.000Inches ± 0.030	2.030	2,002	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																											
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																																																									
Description Work Order		DART AEROSPACE Container No: S088879 Part: D2278 Job No: 179672 Serial No/Batch: S088879 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/03/18 DART AEROSPACE UART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 819 632-6200 Email: sales@dartaero.com www.dartaerospace.com		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																																									
Root Cause <table style="width:100%;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	<table style="width:100%;"> <tr> <td>☐ Cuffs</td> <td>☐ Contamination</td> <td>☐ Out of Sequence</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ Countersink</td> <td>☐ Off-set</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ Heat Treat</td> <td>☐ Cut Too Short</td> <td>☐ Mislabeled</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Wave/Twist in Tube</td> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Fit/Function</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Misaligned/off center</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td colspan="3"></td> <td>☐ Part Moved</td> </tr> <tr> <td colspan="3"></td> <td>☐ Drawing</td> </tr> <tr> <td colspan="3"></td> <td>☐ Finish</td> </tr> <tr> <td colspan="3"></td> <td>☐ Misread</td> </tr> <tr> <td colspan="3"></td> <td>☐ Turning Sequence</td> </tr> </table>				☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Positioned Wrong	☐ Crushing	☐ Countersink	☐ Off-set	☐ Outside Dimensions	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Over/Under tolerance	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Part Incorrect	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Part Lost/Missing				☐ Part Moved				☐ Drawing				☐ Finish				☐ Misread				☐ Turning Sequence
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			1.970	
7	Leg	4.740Inches ± 0.030	4.770 4.710	4,749
8	Leg	8.460Inches ± 0.030	8.490 8.430	8,466
9	Leg	0.213Inches ± 0.010	0.223 0.203	0,214
10	Leg	0.750Inches ± 0.010	0.760 0.740	0,752
11	Leg	0.080Inches ± 0.010	0.090 0.070	0,080 thick

Plex 6/20/18 4:25 PM Dart.lajeunesse.marie

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WORK ORDER NON-CONFORMANCE / UPDATE



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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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